

Date: Thursday, 10/18/2007 8:03:36 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 35214	
Estimate Number : 10554	
P.O. Number : <u>N/A</u>	Part Number : D34431
This Issue : 10/18/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3443 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 33707	Material : <u>N/A</u>
Written By : _____	Due Date : 11/5/2007 Qty: 8 Um: Each
Checked & Approved By : <u>10/02.10.18</u>	
Comment : A 05.11.14 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B2500X1250	17-4 SS BAR
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Comment: Qty.: 0.2100 f(s)/Unit Total : 1.6800 f(s)
Material: 17-4 SS Bar 2.500" X 1.250"
(M17-4-B2.500x01.250)
Batch: M101422

SA 07.11.27

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blank 2.400 " long

SA 07.11.27

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA587 Rev: Δ & Dwg D3443 Rev: B

Mk / SF 07-12-12 (8)

PTO

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Mk / SF 07/12/12 (8)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SF 07.12.13 (8)

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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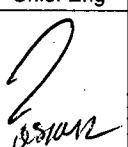


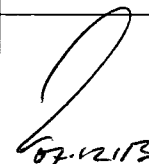
Comment: HAAS CNC VERTICAL MACHINING #1
Tumble & deburr per dwg D3443

Mk 07/12/13 (8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/12/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/12	3.0	Dia of -500 ^{+0.000} _{-0.005} IS oval, because The parts moove in vise and I re-pass IT so the Diameter is now oval.		Scrap; replace Qty 1. M 101422 Qty 1	S.F. 07/12/12	 07.12.13	 07/12/12	 07.12.13

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:03:36 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 35214

Part Number: D34431

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.12.14

(8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 93

7/12/17 56 8X

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/12/18

Job Completion



2007/12/17

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order:	35214
Description: Lug		Part Number:	D3443-1
Inspection Dwg: D3443 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

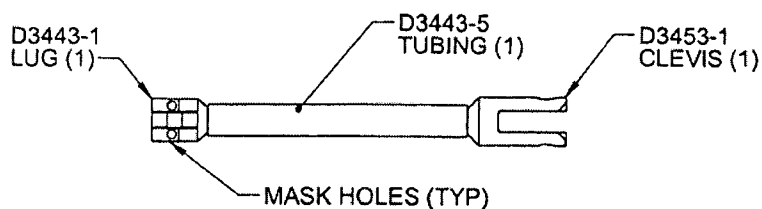
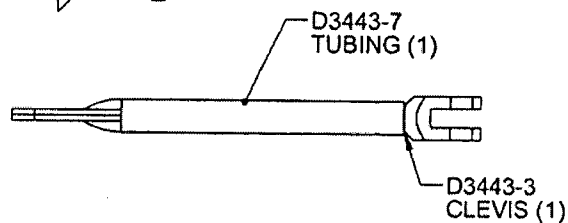
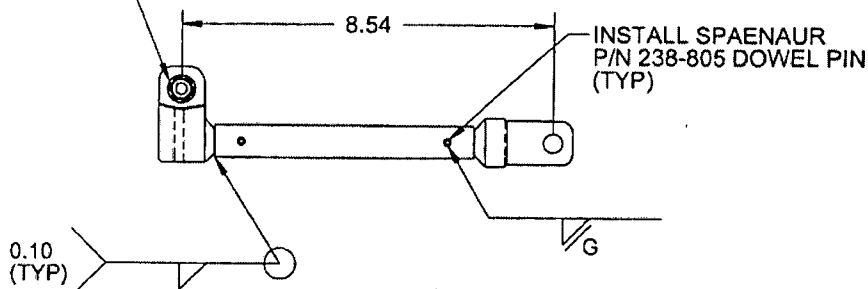
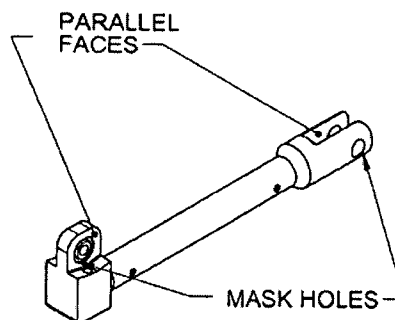
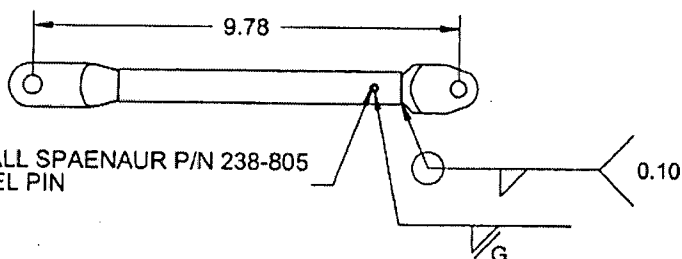
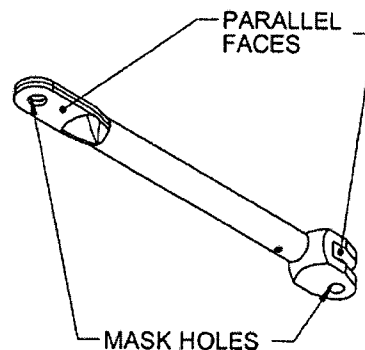
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.000	/			
0.342	+0.000/-0.005	.341	/			
0.329	+/-0.010	.326	/			
Ø0.500	+0.000/-0.005	.499	/			
2.21	+/-0.030	2.217	/			
Ø0.656	+0.000/-0.001	.655	/			
0.625	+/-0.010	.628	/			
0.95	+/-0.030	.955	/			
2.230	+/-0.010	2.230	✓			
0.229	+/-0.010	.230	✓			
0.370	+/-0.010	.375	/			
0.525	+/-0.010	.526	/			
0.524	+/-0.010	.525	✓			
0.390	+/-0.010	.395	/			
1.048	+/-0.010	1.047	✓			
0.05 x 45°	+/-0.5°	.045	/			
R0.032	+/-0.010	.032	✓			
0.470	+/-0.010	.469	✓			
0.165	+/-0.010	.164	✓			
1/4-28UNF	N/A					

Measured by: <i>SF</i>	Audited by: <i>SG</i>	Prototype Approval:	N/A
Date: 07/12/12	Date: 07.12.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue	KJ/JLM	<i>BE</i>

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

RELEASED05.12.09 *[Signature]*PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COATINSTALL SPAENAU P/N 238-805
DOWEL PIN**D3443-041****D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

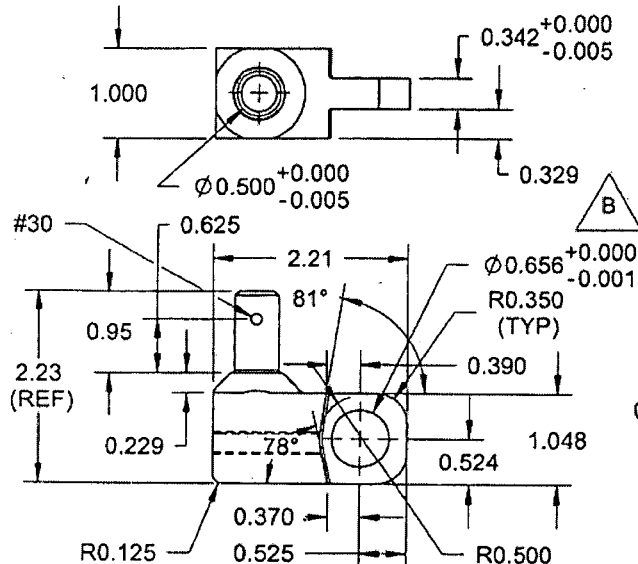
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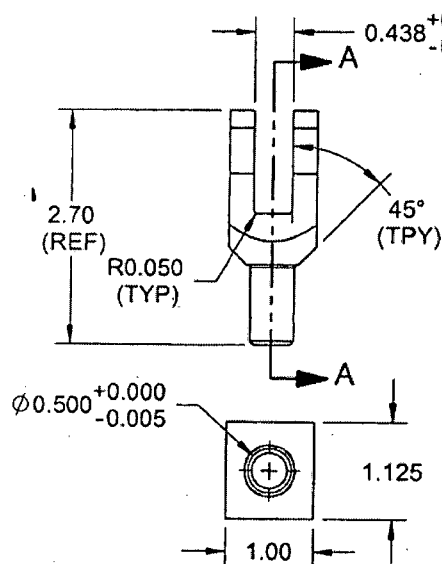
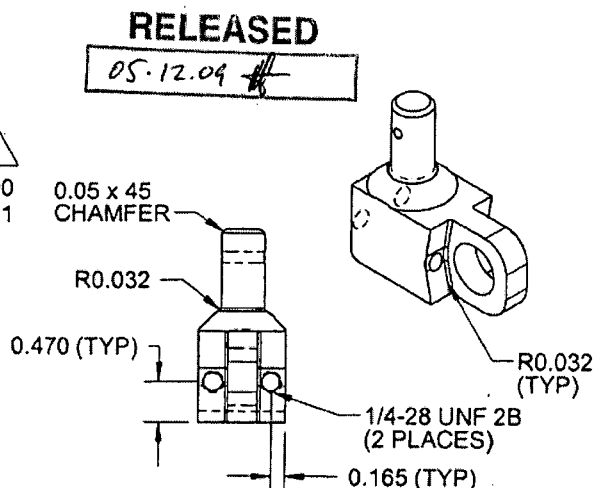
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:2		

**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

D3443-1 LUG**D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SECTION A-A**D3443-3 CLEVIS**

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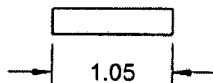
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

$\phi 0.210^{+0.005}_{-0.010}$



D3443-9 PIN

D3443-9 NOTES:

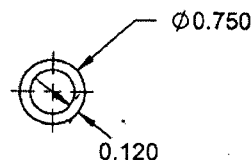
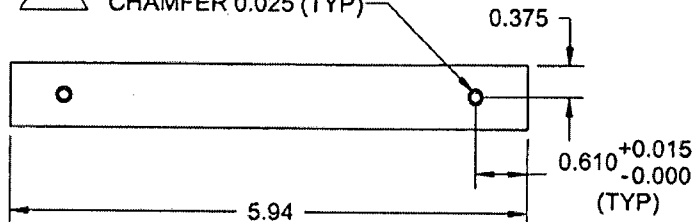
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09 [Signature]

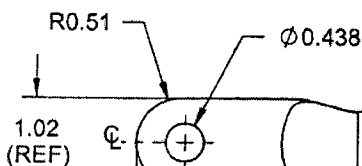
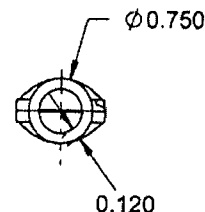
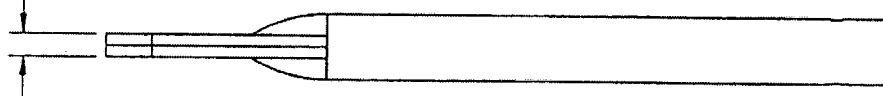


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

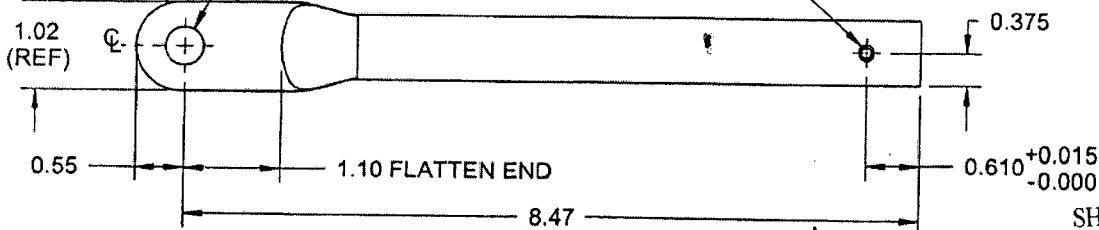


D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



DRILL $\phi 0.125$ THRU
CHAMFER 0.025



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W(120))
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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